

# Work Order ID 81730

**\*81730\***

Page 1

March-19-12 8:45:01 AM

Item ID: D4101-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 29/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/19 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4101	B								
100	Cut blanks as per folio	0.00							
<b>*100*</b>									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	5.00" LONG								
110		0.00							
<b>*110*</b>									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	Mill as per dwg and Folio FA947								
	DEBURR								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

12 0 12/03/26

25 12-03-28

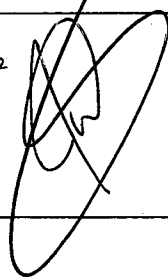
(P40) →

25 12-03-28

# Dart Aerospace Ltd

W/O: 81730		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4101-1    PAR #:    Fault Category: Machining    NCR: (1) Yes No    DQA: Not    Date: 12/09/04  
 Resolution: Scrap    Disposition: Scrap    QA: N/C Closed:    Date:   

NCR: 12-1310		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action    Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
120327	110	no offset for <del>holder</del> the length of the tool out of holder - holder ground part of the part PS Polia not clear	S 12/3/27 as per	scrap + replace Qty x1 M 112330	RT 120327		S 12/3/27 as per	S 12/3/27

NOTE: Date & initial all entries

# Work Order ID 81730

March-19-12 8:45:01 AM

**\*81730\***

Page 2

Item ID: D4101-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 29/03/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 29/03/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		B-A 12/03/29		12	0		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				12		12-3-29	
150 <b>*150*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				12		12-3-29	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81730

**\*81730\***

Page 3

March-19-12 8:45:01 AM

Item ID: D4101-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 29/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location

*STGA*

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

*(124) SP12-03-30*

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

*12/4/2*

*12-03-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-19-12 8:45:06 AM

Page 1

Work Order ID: 81730

**\*81730\***

Parent Item: D4101-1

**\*D4101-1\***

Parent Item Name: Bracket

Start Date: 29/03/2012

Required Date: 29/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-07-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X04.50 0		Purchased	No			100	f	11.0000	0.416	5.254737			

**\*M6061T6B2 000X04 500\***

6061T6 Bar 2.00 x 4.500

**\*\***

5.250'

*sf 12/03/26*

Location

Loc Qty

Loc Code

MAT008

11

112330

11

5.250'

# Dart Aerospace Ltd

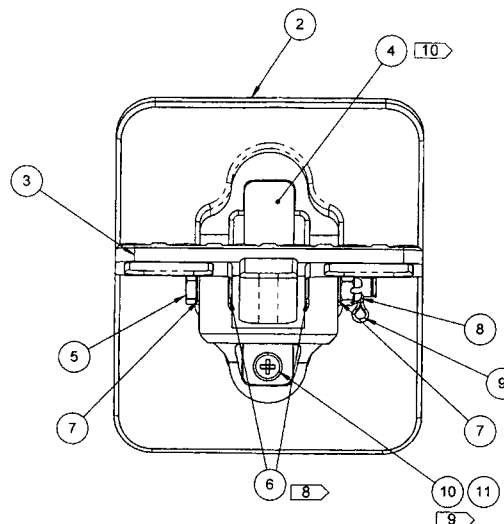
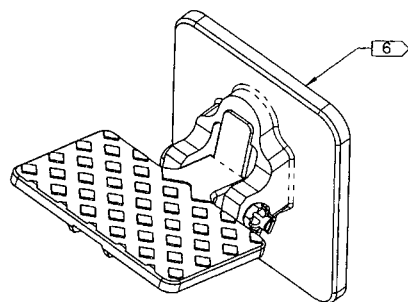
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4101-041 PRE-FLIGHT STEP ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4101-041" USING FINE POINT PERMANENT INK MARKER BACK SURFACE
- 7) WEIGHT: 1.18 lbs
- 8) INSTALL NAS1149D0432J WASHER IN BETWEEN STEP AND BRACKET MATING FACES
- 9) TORQUE AN525832R SCREW TO 15-25 in-lb
- 10) TEXTURED SIDE TO BOTTOM

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4101-041	PRE-FLIGHT STEP ASSEMBLY
2	1	D4101-1	BRACKET
3	1	D4101-3	STEP
4	1	D4101-5	SPRING
5	1	AN4-22	BOLT
6	2	NAS1149D0432J	WASHER
7	2	NAS1149D0463J	WASHER
8	1	AN310-4	NUT
9	1	MS24665-136	COTTER PIN
10	1	AN525-832R6	SCREW
11	1	MS21209C0815	HELICOIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 81730 MLC

12/03/19

**RELEASED**  
2010-08-23

B	NAS1149D0432J WAS NAS1149D0416J (ZN D3-1); ADD SCREW AND HELICOIL (ZN D3-1& B1-3); RE-DESIGN D4101-5 (ZN B4-5)	RF	10.08.05
A	NEW ISSUE	RF	10.07.12
REV	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	10.08.05		

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

**D4101**

REV. B

SHEET 1 OF 5

TITLE

**PRE-FLIGHT STEP ASSEMBLY**

SCALE NTS

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# Dart Aerospace Ltd

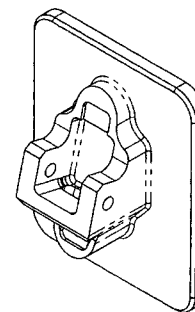
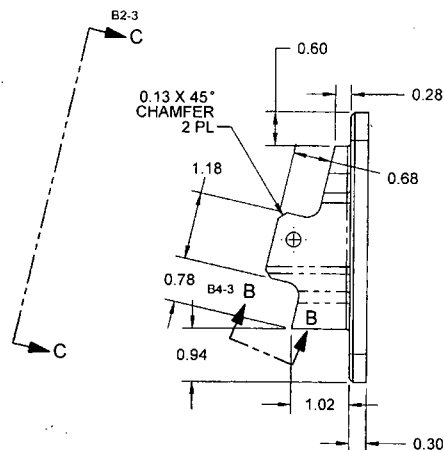
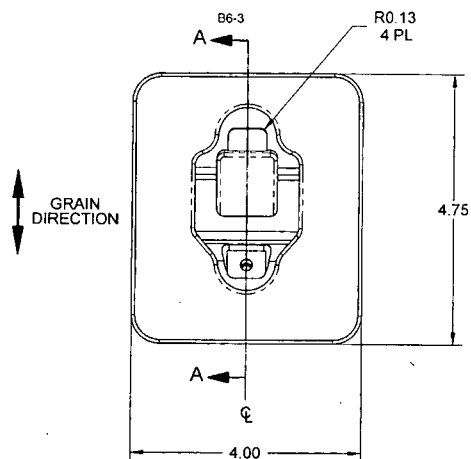
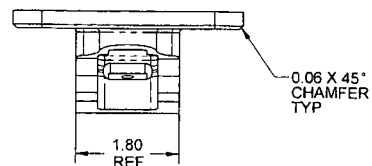
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



81730

# **D4101-1 BRACKET**

**RELEASED**  
2010-08-23

## **NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.85 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4101	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PRE-FLIGHT STEP ASSEMBLY	NTS
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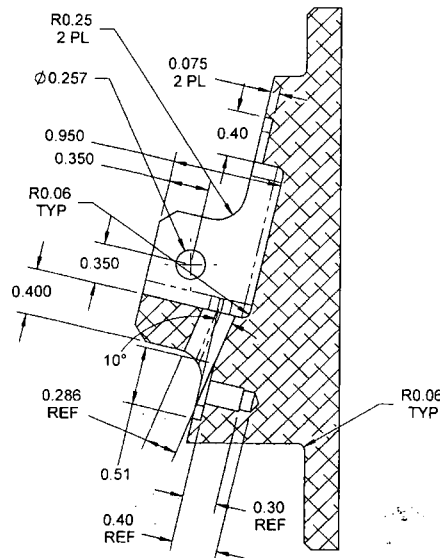
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

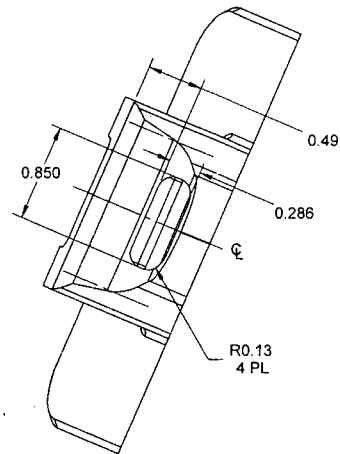
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

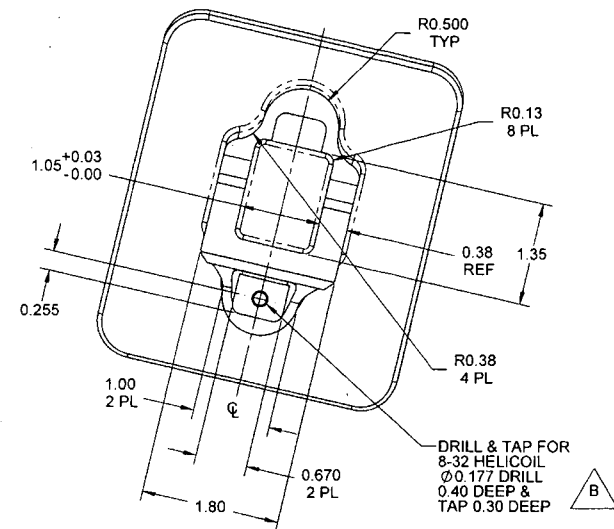
**NOTE:** Date & initial all entries



**SECTION A-A** C7-2  
SCALE 2X



**VIEW B-B** C4-2  
SCALE 2X



**VIEW C-C** D4-2  
SCALE X1.5

**RELEASED**  
2010-08-23

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DRAWN	RF		
CHECKED	<del>RF</del>	DRAWING NO. <b>D4101</b>	REV. B
MFG. APPR.	<del>RF</del>	SHEET 3 OF 5	
APPROVED	<del>RF</del>	SCALE	
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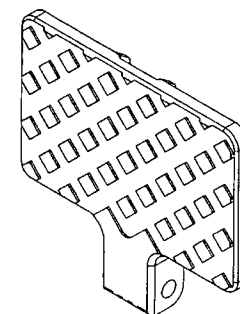
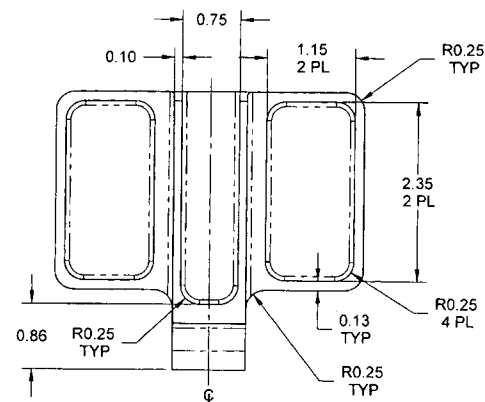
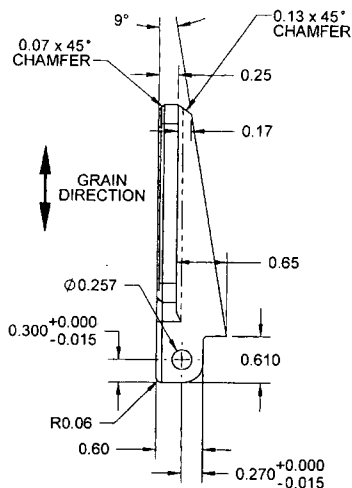
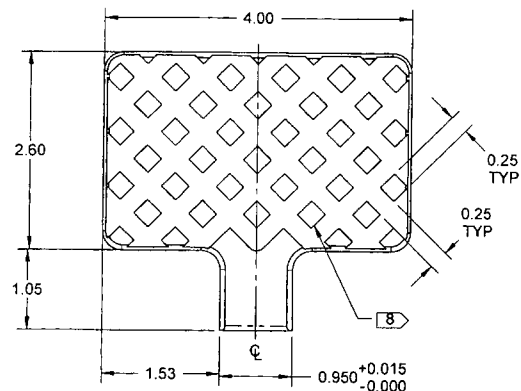
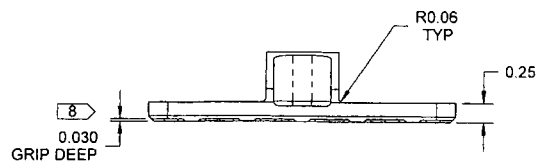
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



81730

# **D4101-3 STEP**

## **NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) MACHINE 0.25 x 0.25 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

**RELEASED**  
2010-08-23

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO. <b>D4101</b>	REV. B
MFG. APPR.	<del>RF</del>	SHEET 4 OF 5	
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	<b>PRE-FLIGHT STEP ASSEMBLY</b>	
DATE	<b>10.08.05</b>	NTS	

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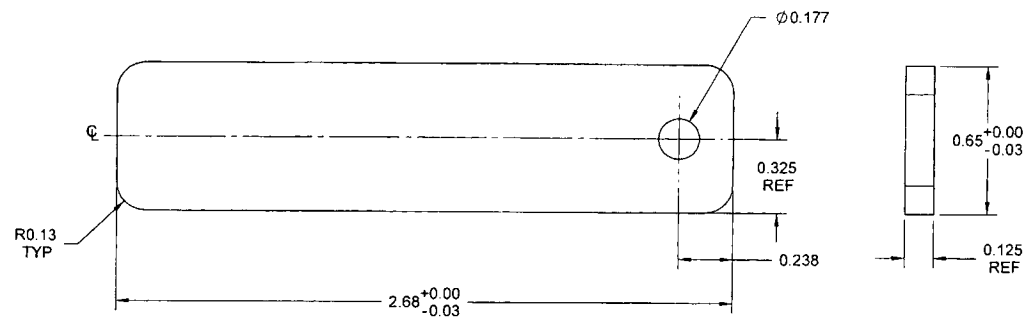
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR: Yes No** **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4101-5 SPRING**



**NOTES:**

- 1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK  
REF DART SPEC MLEXS. 125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

**RELEASED**  
2010-08-23

AND

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>RF</del>	D4101	SHEET 5 OF 5
APPROVED	<del>RF</del>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	81730
<b>Description: Bracket</b>		<b>Part Number:</b>	D4101-1
<b>Inspection Dwg: D4101 Rev: B</b>		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06 x 45°	+/-0.030 x 0.5°	.071	✓		vern	85 - 4
1.80	+/-0.030	1.803	✓		"	
R0.13	+/-0.030	.13	✓		"	
4.00	+/-0.030	4.001	✓		"	
4.75	+/-0.030	4.751	✓		"	
0.13 x 45°	+/-0.030 x 0.5°	.134	✓			
1.18	+/-0.030	1.179	✓			
0.78	+/-0.030	.786	✓			
0.94	+/-0.030	.946	✓		depth gauge	85 - 6
1.02	+/-0.030	1.023	✓			
0.30	+/-0.030	.294	✓			
0.68	+/-0.030	.677	✓			
0.28	+/-0.030	.286	✓			
0.60	+/-0.030	.599	✓			
0.400	+/-0.010	.399	✓			
10°	+/-0.5°	10°	✓		as per spec	
0.286	+/-0.010	.294	✓			
0.51	+/-0.030	.51	✓			
0.40	+/-0.030	.415	✓			
R0.06	+/-0.030	.06	✓			
0.40	+/-0.030	.401	✓			
0.075	+/-0.030	.072	✓			
R0.25	+/-0.030	.25	✓			
Ø0.257	+0.006/-0.001	.258	✓			
0.950	+/-0.010	.949	✓			
0.350	+/-0.010	.346	✓			
R0.06	+/-0.030	.06	✓			
0.350	+/-0.010	.347	✓			
0.850	+/-0.010	.848	✓			
R0.13	+/-0.030	.130	✓			
0.49	+/-0.030	.49	✓			
1.05	+0.030/-0.000	1.050	✓			
0.255	+/-0.010	.255	✓			
1.00	+/-0.030	1.00	✓			
0.670	+/-0.010	.667	✓			
R0.38	+/-0.030	.38	✓			
1.35	+/-0.030	1.31	✓			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries